303 500

Work Order ID 102640

102640

ASAP

Wednesday, June 05, 2013 11:10:51 AM

Item ID: D4727-041
Revision ID:
Item Name: Barrel
Start Date: 6/5/2013 **Start Qty:** 12.00 *12*
Required Date: 6/10/2013 **Req'd Qty:** 12.00 *12*
Reference:

200 4c

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** MK **Date:** 13-6-4 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4727	REV A								
110		0.00							
110	Hardinge CNC LATHE SMALL					16	Ø		
Doosan	**Memo**	0.00							
Doosan Lathe	Machine D4727-1 as per folio FB FOLIO REV: N/A DWG REV: A	SS 13-6-10							
	Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120		SS 13-6-10				16	Ø		
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 102640

102640

Wednesday, June 05, 2013 11:10:51 AM

Item ID: D4727-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Barrel

Start Date: 6/5/2013 **Start Qty:** 12.00 *12* **Cust Item ID:**

Required Date: 6/10/2013 **Req'd Qty:** 12.00 *12* **Customer:**

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				16	0		
130									
QC	**Memo**	0.00							
Quality Control									
140		0.00				16	0		FF 13-06-10
140									
Small Fab	**Memo**	0.00							
Small Fab	ASSEMBLE INSERT IN BARREL AS PER DWG								
150	QC5- Inspect part completeness to step on W/O	0.00				(16)			DAS 06.13.10
150									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Heat Treat
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☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 102640

102640

Wednesday, June 05, 2013 11:10:51 AM

Item ID: D4727-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Barrel

Start Date: 6/5/2013 **Start Qty:** 12.00 *12* **Cust Item ID:**

Required Date: 6/10/2013 **Req'd Qty:** 12.00 *12* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:_____	0.00					5/30		
160							5/31/11		GG
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170							13/6/11		
QC	**Memo**	0.00							
Quality Control									

MF

13-6-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

Wednesday, June 05, 2013 11:10:50 AM

Work Order ID: 102640
Parent Item: D4727-041
Parent Item Name: Barrel
Start Date: 6/5/2013 **Required Date:** 6/10/2013
Start Qty: 12.00 **Required Qty:** 12.00
Comments: IPP REV:A 12.10.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500 303 Round Bar 0.500"		Purchased	No			110	f	60.7733	0.054	0.6821053	SA	13-6-9	

Location	Loc Qty	Loc Code	
MAT028	60.77330000		
124081	1E-09		
124711	28.2		
125387	32.5733		1.25

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21209F1-15 HELI COIL		Purchased	No			140	Each	48.0000	1	12	FF	13-06-10	

Location	Loc Qty	Loc Code	
ST319	48		
121166	4		
123935	44		12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

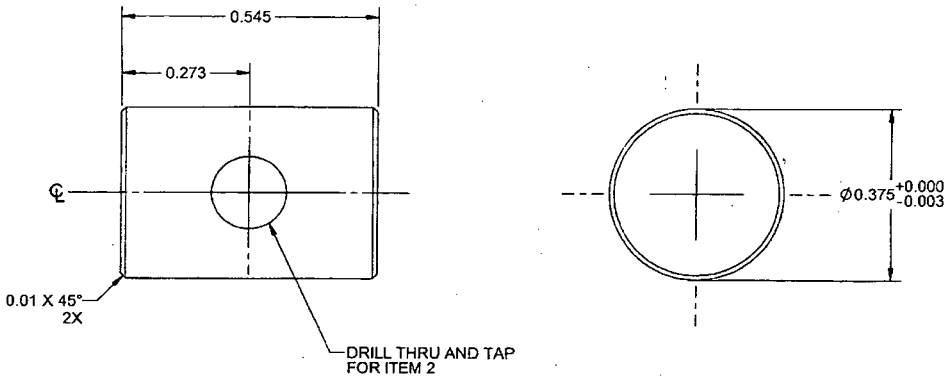
Landing Gear

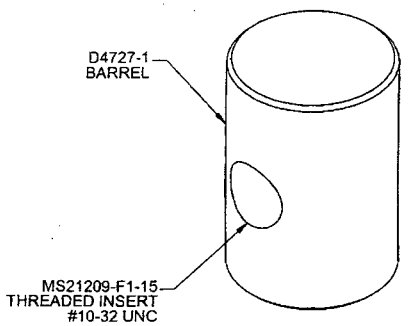
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☐ Wrong Stock Pulled
☐ Other

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4727-041	BARREL
1	1	D4727-1	BARREL
2	1	MS21209-F1-15	THREADED INSERT, #10-32 UNC





D4727-041 BARREL

#1021640

D4727-1 BARREL

2012-10-12

NOTES:

1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303R1.000 OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R1.000
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RP	12.09.19

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	RP	KENT, WA	
CHECKED	AP	DRAWING NO. D4727	REV. A
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE BARREL	SCALE NTS
DE APPR.			
DATE	12.09.19		

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
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Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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Handling/Pre	☐									
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Operator	☐									
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Training	☐									
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FAULT CATEGORY

Landing Gear

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DART AEROSPACE LTD	Work Order:	102640
Description: Barrel	Part Number:	N4727-04
Inspection Dwg: 4727-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.545	±.010	.545	✓		A-9	Verify
.273	±.010	.272	✓			
.01X45°	±.030/±.5°	.015X45°	✓			
Ø.375	+.000/-.003	.373	✓			

Measured by:		Audited by:		Preliminary Approval:	
Date:	13-6-9	Date:	13/06/10	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15